

Ship April 28

Work Order ID 131646

131646

Page 1

Monday, April 20, 2015 4:18:13 PM

Item ID: D120-639-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: OEM Replacement Wearplate (s/n 1001 thru 1390)
 Start Date: 4/20/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/24/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: 15-4-20 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9223	Rev A								
IIN-D120-639	Rev A								

100 Document Control 0.00
 100
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile and type labels per PPP D120-639-011 CHG 002

105 Pick Kit 0.00
 105
 Packaging Memo 0.00
 Packaging

DAS
 27
 9-29
 APR 23 2015

DAS
 28
 9-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS				
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				
								Completed By
								Lead hand / Supervisor Approval Verification
								QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY						
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐		

Work Order ID 131646***131646***

Page 2

Monday, April 20, 2015 4:18:13 PM

Item ID: D120-639-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: OEM Replacement Wearplate (s/n 1001 thru 1390)

Start Date: 4/20/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/24/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC4- 100% Inspect kits for completeness	0.00							APR 27 2015

110

QC

Memo

0.00

Quality Control

120

120

Packaging

Memo

0.00

Packaging

Package and Identify as per PPP D120-639-011

130

130

QC

Memo

0.00

Quality Control

DAS
26
9-89

ship MF 15-4-28

MCS 15-04-28

MF
15-4-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Monday, April 20, 2015 4:18:17 PM

Page 1

Work Order ID: 131646

131646

Parent Item: D120-639-011

D120-639-011

Parent Item Name: OEM Replacement Wearplate (s/n 1001 thru 1390)

Start Date: 4/20/15

Required Date: 4/24/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP D 02.09.13 Re-format, Added MS27130-S30 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2746		Manufactured	No			105	Each	8.0000	1	1			
D2746									**			DAS 27 9-89	DAS 28 9-89
Wearplate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST601	128891	8							
					86438	4							
					91907	1							
						3							

D2656-31		Manufactured	No			105	Each	10.0000	1	1			
D2656-31									**			DAS 27 9-89	DAS 28 9-89
Wearplate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST603	105355	10							
					115771	1							
					86259	8							
						1							

D2656-13		Manufactured	No			105	Each	1.0000	1	1			
D2656-13									**			DAS 27 9-89	DAS 28 9-89
Wearplate Fwd													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST603	101555	1							
						1							

APR 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

Monday, April 20, 2015 4:18:17 PM

Work Order ID: 131646

131646

Parent Item: D120-639-011

D120-639-011

Parent Item Name: OEM Replacement Wearplate (s/n 1001 thru 1390)

Start Date: 4/20/15

Required Date: 4/24/15

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

AELS8-1032-130

Purchased

No

105

Each

5,492.000

36 40x 36 40x 36x

ALS7-1032-130

Rivnut

Location

Loc Qty

Loc Code

FG

100

121444

100

FP001

422

M128649

422

st549

4970

M128649

4970

105

Each

19.0000

40 5 15

D2648-3

Manufactured

No

D2648-3

Wearpad

Location

Loc Qty

Loc Code

FG

8

85490

8

ST601

11

119444

11

105

Each

1,070.000

40 40

MS27039-1-08

Purchased

No

MS27039-1-08

Screw

Location

Loc Qty

Loc Code

CA

96

m128636

96

FP001

413

m128636

413

GA

2

125654

2

ST285

559

m128636

559

DAS
27
9-89

DAS
28
9-89

DAS
27
9-89

DAS
28
9-89

DAS
27
9-89

APR 23 2015

DAS
28
9-89

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OTHER : ☐																					

Picklist Print

Page 3

Monday, April 20, 2015 4:18:18 PM

Work Order ID: 131646

131646

Parent Item: D120-639-011

D120-639-011

Parent Item Name: OEM Replacement Wearplate (s/n 1001 thru 1390)

Start Date: 4/20/15

Required Date: 4/24/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

105

Each

1,341.000

40

40

NAS1149D0332.J

Washer

DAS

27

9-89

DAS

28

9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

CA

14

m129682

14

ST269

1327

m130325

879

m131624

448

4

MS27130-S30

Purchased

No

105

Each

79.0000

4

4

MS27130-S30

Insert

DAS

27

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

ST279

79

100154

79

4

APR 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9223	REV. A SHEET 1 OF 1
DATE 01.11.19		TITLE WEARPLATE INSERTS	SCALE NTS
A	01.11.19	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS

IIN-D120-639 Rev. A

REF. CANADIAN STC SH01-25

FAA STC: SR01347NY

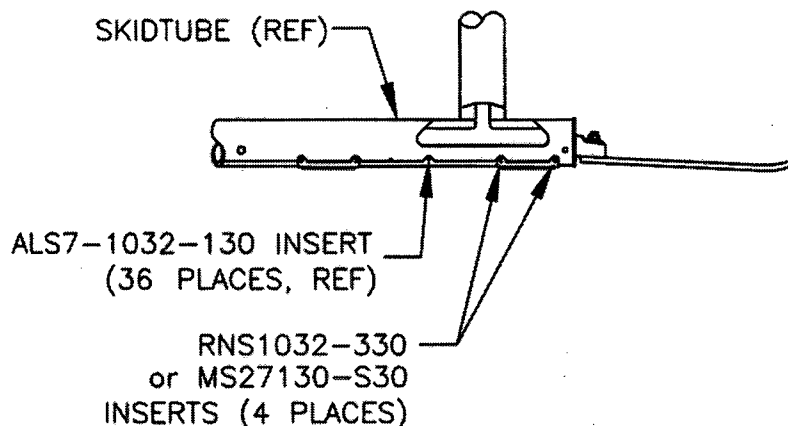
REPLACE (4) AFTMOST ALS7-1032-130 INSERTS WITH (4) RNS1032-330 / MS27130-S30 INSERTS.
UPDATE PARTS LIST AS FOLLOWS:

REPLACE:

QTY -011	QTY -013	Part Number	Description
40	40	ALS7-1032-130	INSERT

WITH:

QTY -011	QTY -013	Part Number	Description
36	36	ALS7-1032-130	INSERT
4	4	RNS1032-330 or MS27130-S30	INSERT



NOTE: OPEN HOLES TO $\phi 0.250$ INSTEAD
OF $\phi 0.297$ FOR THESE 4 INSERTS

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: NOV 19, 2001
CERT. NO.: SH01-25
ISSUE NO.: 1

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Ref.

DAS
26
9-99

APR 27 2015

4.0 WEIGHT AND BALANCE

The following weight and balance information is for the Dart wearplate kits that are being installed. The weight and balance of any wearplates that are being removed from the aircraft is the responsibility of the installer.

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D120-639-011 TUNGSTEN CARBIDE WEARPLATE KIT	3.1 lb 1.4 kg	136.0 in 3.45 m	422 in lb 4.8 m kg	±40.7 in ±1.04 m	±126 in lb ±1.5 m kg
D120-639-013 SURFACITE™ WEARPLATE KIT	4.1 lb 1.8 kg	136.0 in 3.45 m	558 in lb 6.2 m kg	±40.7 in ±1.04 m	±167 in lb ±1.9 m kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D120-639-011	TUNGSTEN CARBIDE WEARPLATE KIT
	X	D120-639-013	SURFACITE™ WEARPLATE KIT
(1)	1	D2746	WEARPLATE
(1)	1	D2656-31	WEARPLATE
(1)	1	D2656-13	WEARPLATE
(5)		D2648-3	WEARPAD
	5	D2648-7	WEARPAD
(40)	40	ALS7-1032-130 or AKS7-1032-130 or ALS4-1032-130 or AKS4-1032-130	INSERT
(40)	40	MS27039-1-08	SCREW
(40)	40	AN960JD10L	WASHER

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Revision: **A**
Date: 00.12.11

DART

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9223	REV. A SHEET 1 OF 1
DATE 01.11.19		TITLE WEARPLATE INSERTS	SCALE NTS
A	01.11.19	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS

IIN-D120-639 Rev. A

REF. CANADIAN STC SH01-25

FAA STC: SR01347NY

REPLACE (4) AFTMOST ALS7-1032-130 INSERTS WITH (4) RNS1032-330 / MS27130-S30 INSERTS.
UPDATE PARTS LIST AS FOLLOWS:

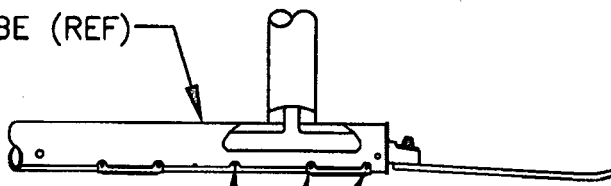
REPLACE:

QTY -011	QTY -013	Part Number	Description
40	40	ALS7-1032-130	INSERT

WITH:

QTY -011	QTY -013	Part Number	Description
36	36	ALS7-1032-130	INSERT
4	4	RNS1032-330 or MS27130-S30	INSERT

SKIDTUBE (REF)

ALS7-1032-130 INSERT
(36 PLACES, REF)RNS1032-330
or MS27130-S30
INSERTS (4 PLACES)

NOTE: OPEN HOLES TO $\varnothing 0.250$ INSTEAD
OF $\varnothing 0.297$ FOR THESE 4 INSERTS

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVEDBY: 
D. SHEPHERD (DE # 02)DATE: NOV 19, 2001
CERT. NO.: SH01-25
ISSUE NO.: 1

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